

Work Order ID 82134***82134***

Page 1

March-23-12 10:47:12 AM

Item ID: D2939-2 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Saddle RH In, 206
Start Date: 23/03/2012 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 06/04/2012 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: 4L5 Date: 12/03/23 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2939	Rev C								

100
100 HAAS CNC VERTICAL MACHINING #1 0.00 OK/FK 12/04/02 4
HAAS I Memo 0.00
HAAS CNC vertical machine #1 Program part number and batch number.1-Inspect part number and batch number are programmed correctly.2-Machine Step No 1 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per

110
110 CONVENTIONAL MILLING MACHINE 0.00 OK/FK 12/04/02 4
Mill Conv Memo 0.00
Conventional Milling Machine Machine Keyway and inspect per attached dimension sheet

120
120 QC1- Inspect dimensions to dimension sheet 0.00 OK/FK 12/04/02 4
QC Memo 0.00
Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		DL 12/04/02					
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							H 12-4-2
150 *150* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: 3:50 4:20 FINISH TIME: 3:20	0.00 0.00							4 & (2P) 12/04/02 M120222

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: <u>428A</u>	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

H BL 12-4-3

JB (4) 12/04/03

12/4/3

12-04-3

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

March-23-12 10:47:15 AM

Page 1

Work Order ID: 82134

82134

Parent Item: D2939-2

D2939-2

Parent Item Name: Saddle RH In, 206

Start Date: 23/03/2012

Required Date: 06/04/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: B 00.06.26 New DWG rev (mpp 2069)EC
IPP Rev:C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6101-001		Manufactured	No			100	Each	45.0000	1	4			
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D6101-001

Saddle Billet

PO 12/03/29

Location

Loc Qty

Loc Code

MAT040

3

69677

2

76836

1

MAT041

42

80764

42

4

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order:	82134
Description: 206 Saddle, Inboard, Right side		Part Number:	D2939-2
Inspection Dwg: D2939 Rev: C DSK: Rev:		Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
A	0.100	0.140		.118	.118	.118	.117	
B	0.100	0.140		.117	.118	.118	.118	
C	0.100	0.140		.118	.118	.117	.118	
D	0.210	0.230		.222	.222	.222	.222	
E	1.245	1.255		1.250	1.250	1.250	1.250	
F	1.245	1.255		1.250	1.250	1.250	1.250	
G	2.495	2.505		2.500	2.500	2.500	2.500	
H	0.510	0.515		.512	.512	.512	.512	
I	1.572	1.582		1.574	1.574	1.574	1.574	
J	2.495	2.505		2.500	2.500	2.500	2.500	
K	0.257	0.262		.260	.260	.260	.260	
L	0.312	0.317		.314	.314	.314	.314	
M	0.235	0.240		.236	.236	.236	.236	
N	0.100	0.140		.123	.123	.123	.123	
O	0.540	0.560		.550	.550	.550	.550	
P	0.490	0.510		.500	.500	.500	.500	
Q	3.715	3.725		3.720	3.720	3.720	3.720	
R	2.720	2.760		2.740	2.740	2.740	2.740	
S	0.240	0.270		.252	.252	.252	.252	
T	0.100	0.180		.135	.135	.135	.135	
U	1.625	1.635		1.630	1.630	1.630	1.630	
V	1.362	1.372		1.367	1.367	1.367	1.367	
W	0.316	0.321		.316	.316	.316	.316	
X	1.250	1.270		1.260	1.260	1.260	1.260	
Y	1.565	1.585		1.571	1.572	1.572	1.572	
Z	0.178	0.198		.188	.188	.188	.188	
AA								
AB								
AC								
AD								
Accept/Reject								

Measured by: F.K. / <i>amk</i>	Date: 12/04/01
Audited by: <i>JL</i>	Date: 12/04/02
Prototype Approval: N/A	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	
D	07.11.23	DT8695 A/B removed	KJ/EC/DD	<i>DD</i>

Dart Aerospace Ltd

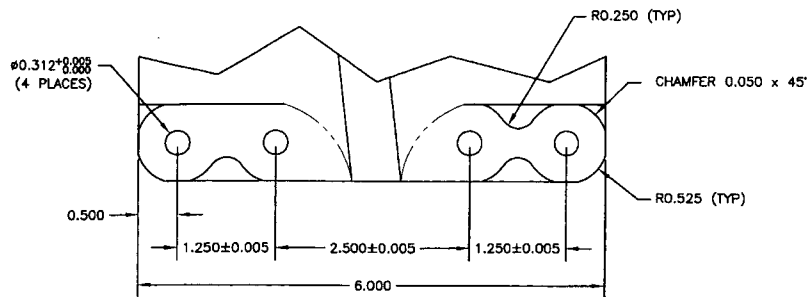
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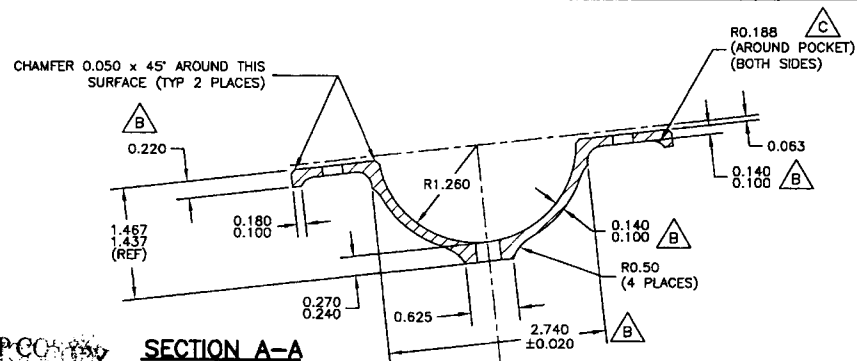
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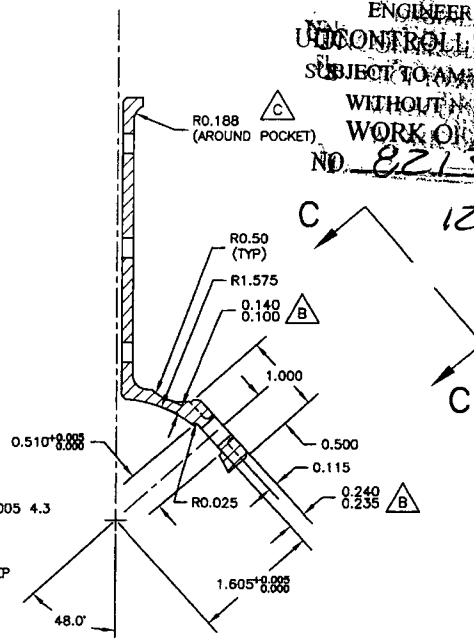


VIEW C-C

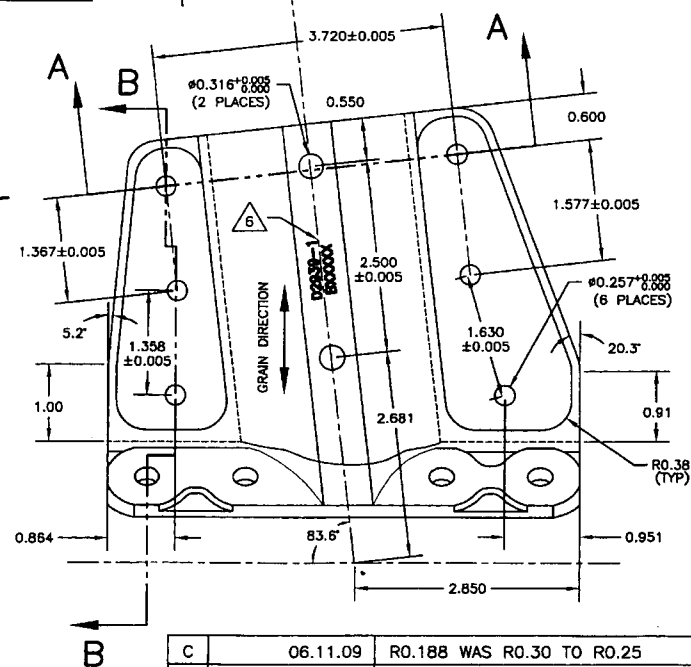


SECTION A-A

D2939-1 LH SADDLE (SHOWN)
D2939-2 RH SADDLE (OPPOSITE)



SECTION B-B



- NOTES:**
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
 - 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE INCHES
 - 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

FILED
07.02.12

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO APPROVAL
WITHOUT MAKING
WORK OFF
NO. 82134 MJS
12/03/23

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED DEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE

DESIGN	BY	DRAWN BY	C.B.	DART DART AEROSPACE USA, INC.
CHECKED	PH	APPROVED	PH	DRAWING NO. D2939
DATE	06.11.09	TITLE	SADDLE INSIDE	REV. C SHEET 1 OF 1 SCALE 2:3

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AND IS SUPPLIED ON THE EXPRESS CONDITION
THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE USA, INC.

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